

Date: Friday, 2/23/2007 1:49:03 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT TUBE ASSEMBLY
Job Number	: 30932		
Estimate Number	: 10699		
P.O. Number	: <u>N/A</u>	Part Number	: D3391025
This Issue	: 2/23/2007	S.O. No.	: <u>N/A</u>
Prsht Rev.	: NC	Drawing Number	: D3391 REV E
First Issue	: <u>N/A</u>	Project Number	: N/A
Previous Run	: 30931	Drawing Revision	: E
	Type : LANDING GEAR	Material	: <u>N/A</u>
Written By	:	Due Date	: 3/21/2007
Checked & Approved By	: <u>JA 07.02.26</u>	Qty:	: 1 Um: Each
Comment	Est Rev B 06-02-07 ECN773 dwg rev. D EC Est Rev:C 06-03-28 Update Manufacturing Instructions JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6014090	ALUMINUM EXTRUSION
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Comment: Qty.: 1.0000 f(s)/Unit Total : 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D6014-090	Extrusion	<u>B26546</u>
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Identify as D3391-3

JF 07/03/09

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: AA & Dwg D3391 Rev: E

JF 07/03/09

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JF 07.03.10 (1)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS

1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: E~~2-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803~~

3-Deburr

JL 07/03/13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 1:49:03 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 30932

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

/ J.L 07/03/13

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 07/03/13

7.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

DP 7-3-14

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BF 07-03-14

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

Pm 07-03-14 (1)

2-Drill Tube as per D3391 using DT8809 (HOLES MARKED "A" ONLY)

Pm 07-03-14 (1)

3-Drill and c'sink wearshoe holes as per Dwg D3391 Using DT8878(Mid Tube) & DT8217 Wearplate Jig

Pm 07-03-14 (1)

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391

Pm 07-03-14 (1)

5-Deburr

Pm 07-03-14 (1)

Tools: rill

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M 07/03/16 (1)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.L

07/03/16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 1:49:03 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 30932

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

POWDER COATING

POWDER COATING



M103706



①

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-h

07/03/16

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

h 07-03-16

14.0

NAS1330C3KB166

INSERT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
8	NAS1330C3KB166	Insert	M100732

m-h 07/03/16

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



①

Comment: HAND FINISHING RESOURCE #1

Install Inserts as per dwg

m-h

07/03/16

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 7-3-16

17.0

AESS10KB366

INSERT



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Insert

Pick:

Qty	Part Number	Description	Batch
14	AESS10KB366	Insert	M103758

M103758

m-h 07/03/16

18.0

AESS10KB266

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
2	AESS10KB266	Insert	M417905

or NAS1330C3KB266

M417905

m-h 07/03/16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 1:49:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 30932

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AESS10KB316

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch
2 AESS10KB316 Insert
or NAS1330C3KB316

M17905

m-h

07/03/16

20.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty Part Number Description Batch
1 D2646 Aft Cap

B30119

21.0

AN3C4A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch
2 AN3C4A Bolt

~~B30119~~ M 101390

22.0

AN960C10L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

Pick:

Qty Part Number Description Batch
2 AN960C10L Washer

M 101692

23.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Pick:

Qty Part Number Description Batch
2 NAS1515H3L Washer

M 103641

m-h 07/03/16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: IP Date: 07/03/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng		Action Description Chief Eng			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 1:49:03 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 30932

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291

Sikaflex expiry date:

M103497
07-10

M-A 07/03/16

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20703-19

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

111 B30918 2/7/3/20

27.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
20703/00

Job Completion



U 07-0320

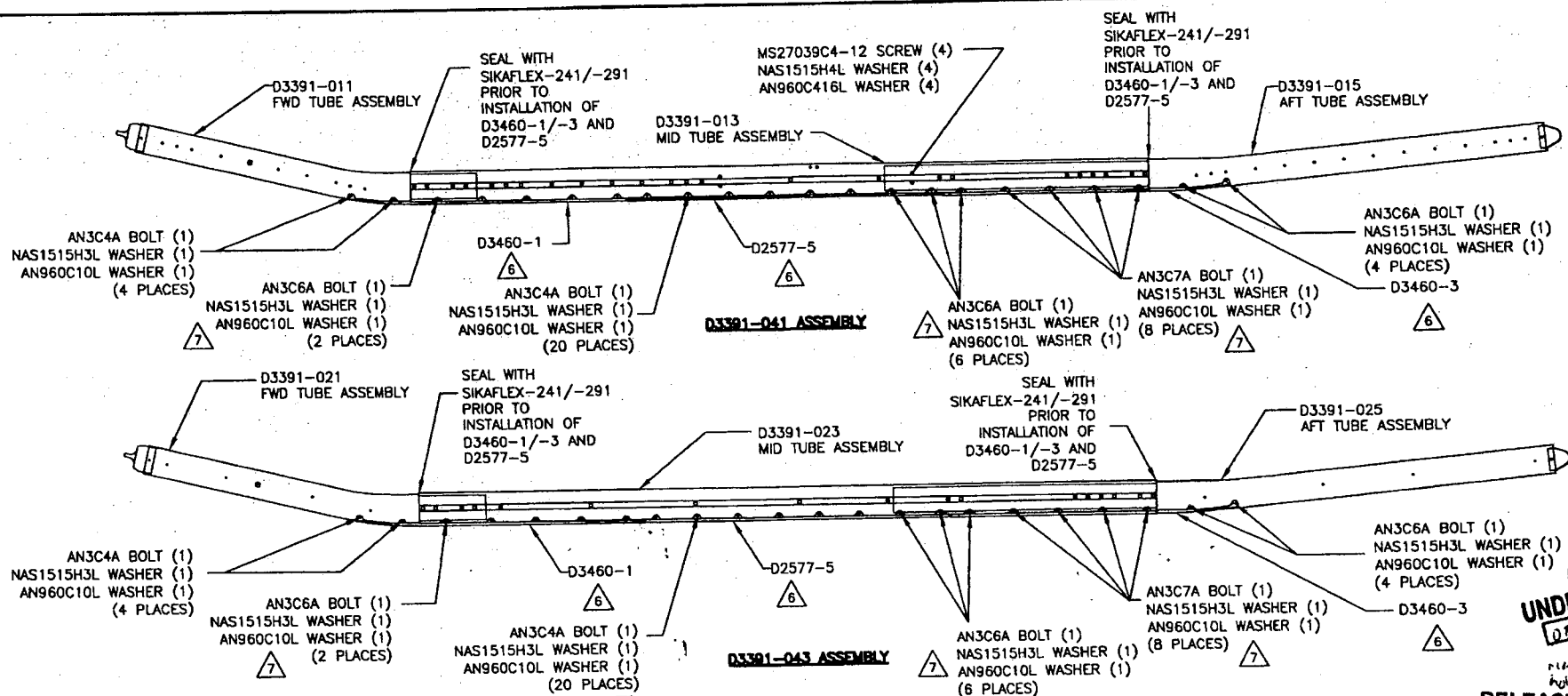
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



GENERAL NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL "E" SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS.
- 6) C/SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 7) APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES

D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	NAS1515H3L	WASHER
44	44	AN960C10L	WASHER
4		MS27039C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
1	1	D2577-5	WEARSHOE
1	1	D3460-1	WEARSHOE
1	1	D3460-3	WEARSHOE

NO ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
RETURN TO
SHOP COPY
ENGINEERING
SUBJECT TO AMENDMENT

UNDER REVIEW
06.05.03
07.02.03
08.01.15
FINISHING DETAIL F
holes smaller

RELEASED

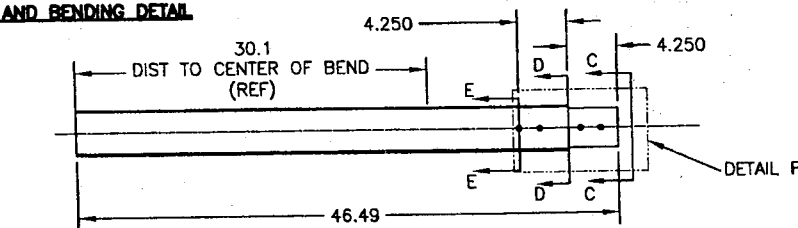
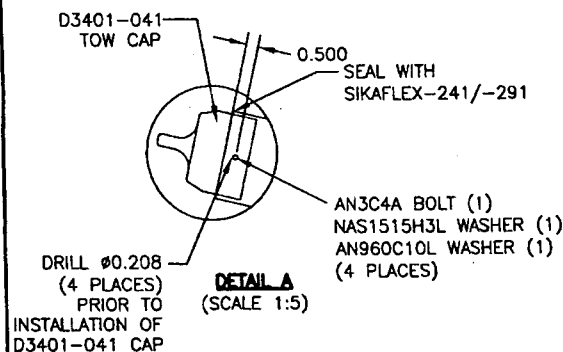
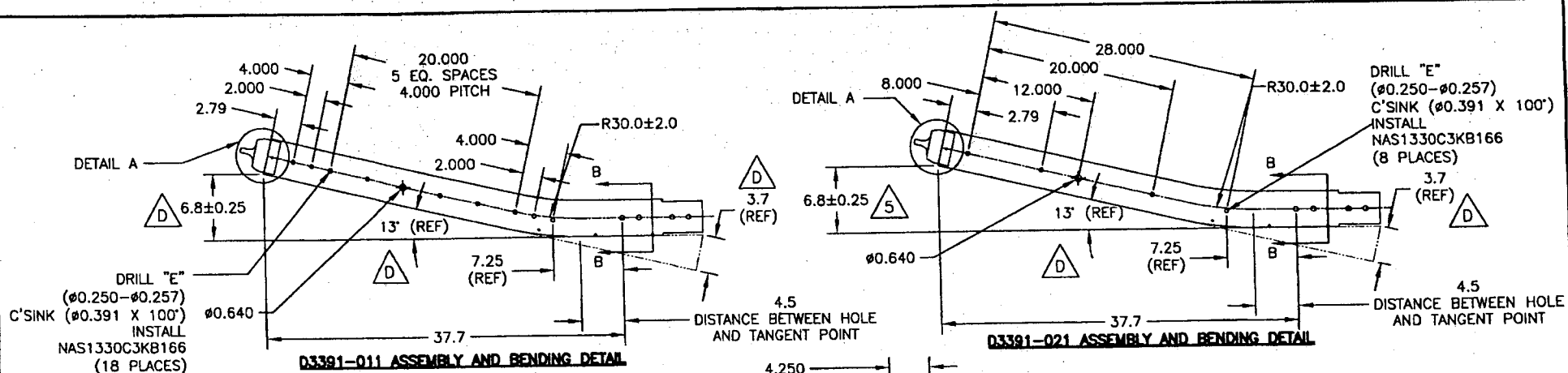
06.05.03

E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	06.04.25	DRAWING NO. D3391
		TITLE 412 FLOAT SKIDTUBE
		REV. E SHEET 1 OF 5 SCALE NTS

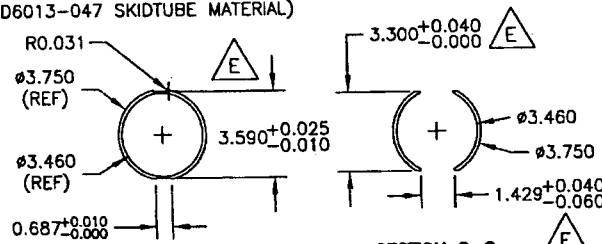
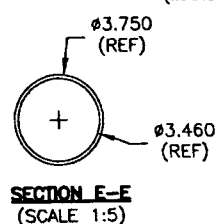
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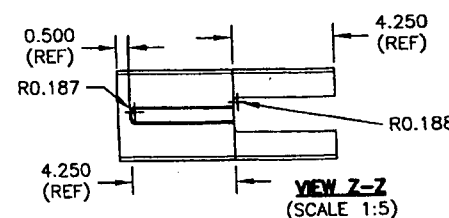
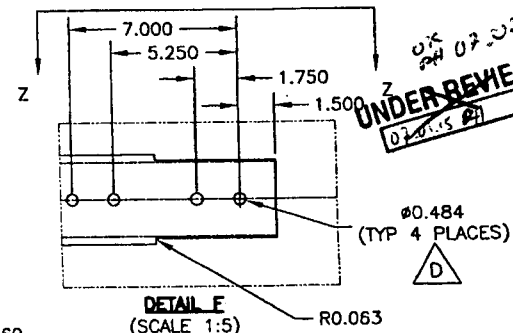
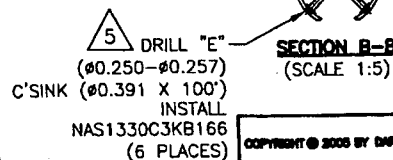
DART AEROSPACE USA, INC.
PORT HADLOCK, OH



D3391-1 DRILLING AND CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



SECTION D-D
(SCALE 1:5)



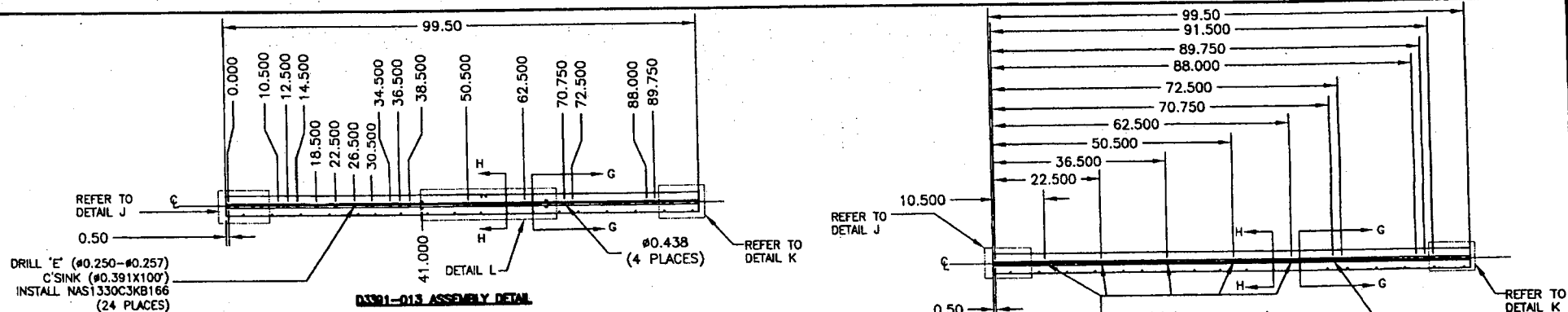
D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
4	4	AN3C4A	BOLT
4	4	NAS1515H-3L	WASHER
4	4	AN960C10L	WASHER
24	14	NAS1330C3KB166	INSERT

UNCONTROLLED COPY
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 30932
WORK ORDER

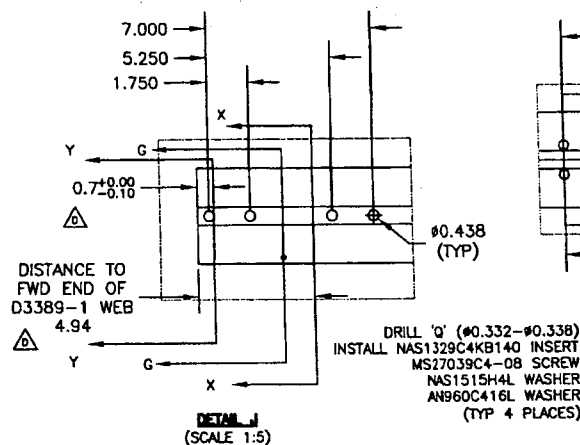
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PH		PH		DART		PORT HADLOCK, MA	
CHECKED		APPROVED		DRAWING NO.		REV. E	
DATE		DATE		D3391		SHEET 2 OF 5	
06.04.25		06.04.25		TITLE		SCALE	
				412 FLOAT SKIDTUBE		1:10	

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RELEASED

06.05.06



D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X		D3391-013	MID TUBE ASSEMBLY
	X	D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330C3KB116	INSERT
24	10	NAS1330C3KB166	INSERT
4		NAS1329C4KB140	INSERT
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

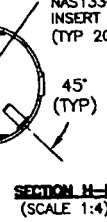
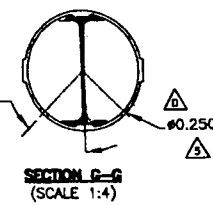
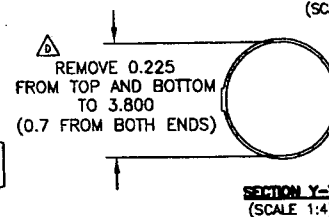
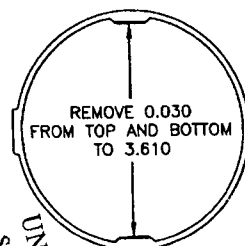
SECTION L-L
(SCALE 1:4)

SECTION M-M
(SCALE 1:4)

SECTION LL-LL
(SCALE 1:4)

DETAIL K (SCALE 1:5)

DISTANCE TO END OF WEB 4.19 (REF)



D3391-013/-023 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER OSI 015

NO. 30932

WORK ORDER

UNCONTROLLED COPY

ENGINEERING

RETURN TO

FOR COPY

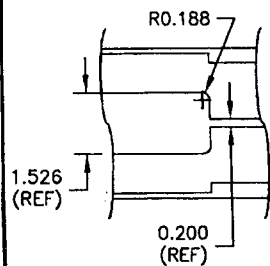
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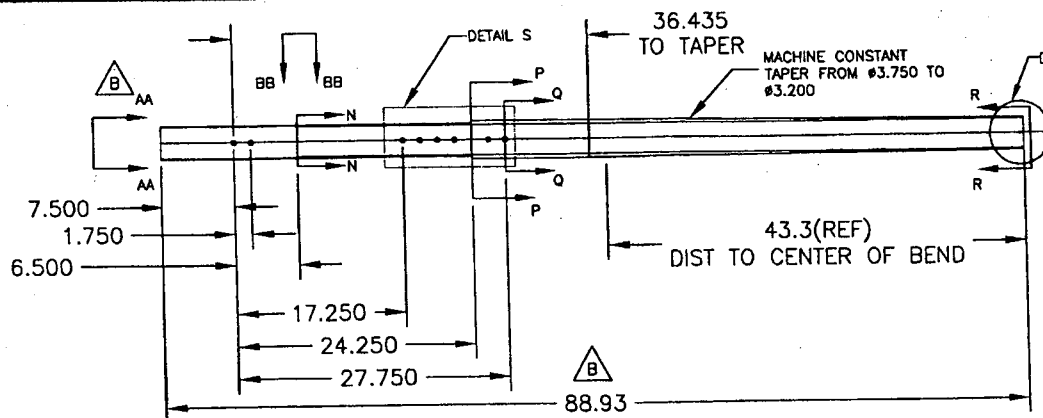
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PH	PH	PH	PH	
CHECKED	APPROVED	CHECKED	APPROVED	DRAWING NO. D3391
DATE	06.04.25	DATE	06.04.25	TITLE 412 FLOAT SKIDTUBE
				REV. E SHEET 3 OF 5 SCALE 1:20

UNDER REVIEW

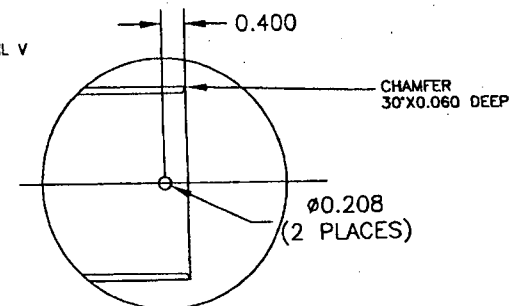
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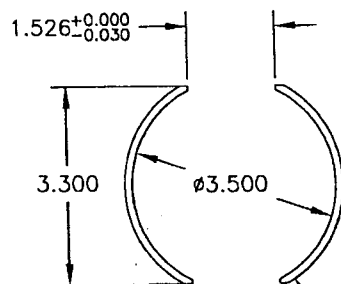
VIEW BB-BB
(SCALE 1:3)



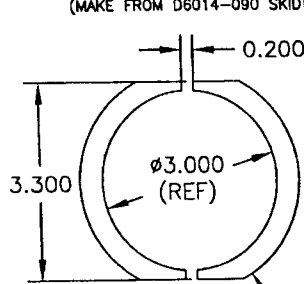
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



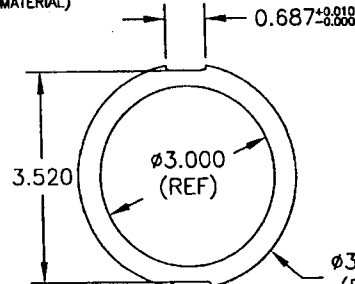
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(SCALE 1:2)



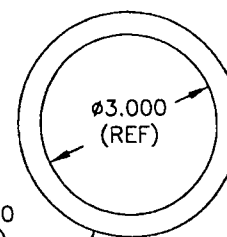
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(SCALE 1:2)



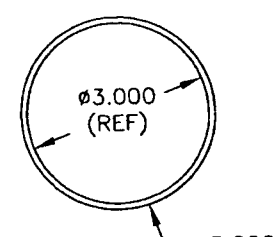
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(SCALE 1:2)



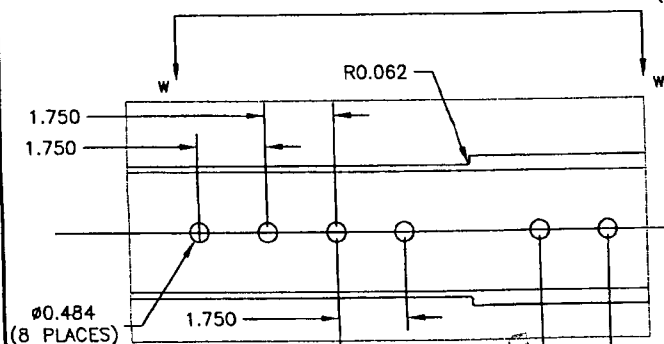
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(SCALE 1:2)



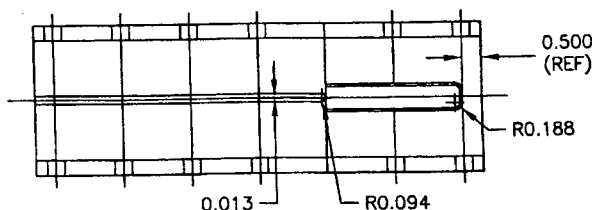
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(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



DETAIL S
(SCALE 1:3)

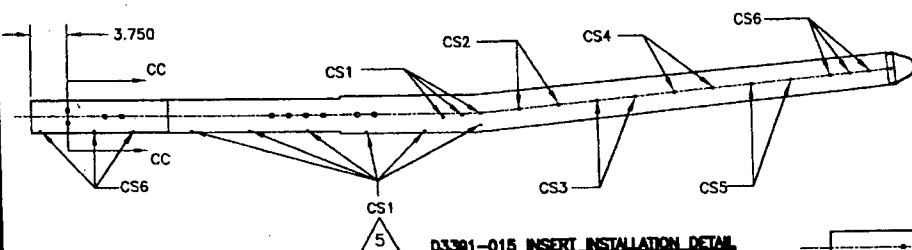
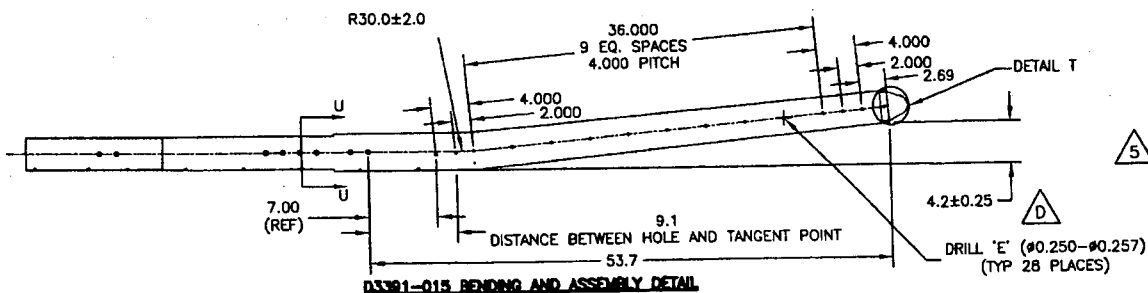


VIEW W-W
(SCALE 1:3)

08 PH 07.02.07
UNDER REVIEW
07.01.04
RELEASED
06.05.03

DESIGN		DRAWN BY		DART DART AEROSPACE USA, INC.	
PH		PH		PORT HADLOCK, OH	
CHECKED		APPROVED		DRAWING NO.	
DATE		DATE		TITLE	
06.04.25		06.04.25		412 FLOAT SKIDTUBE	
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				SCALE	
				1:12	

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WORK ORDER
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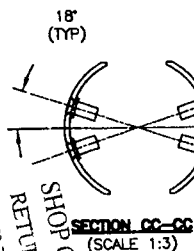
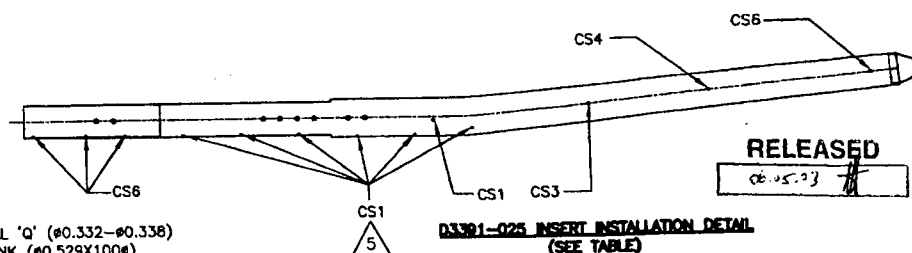
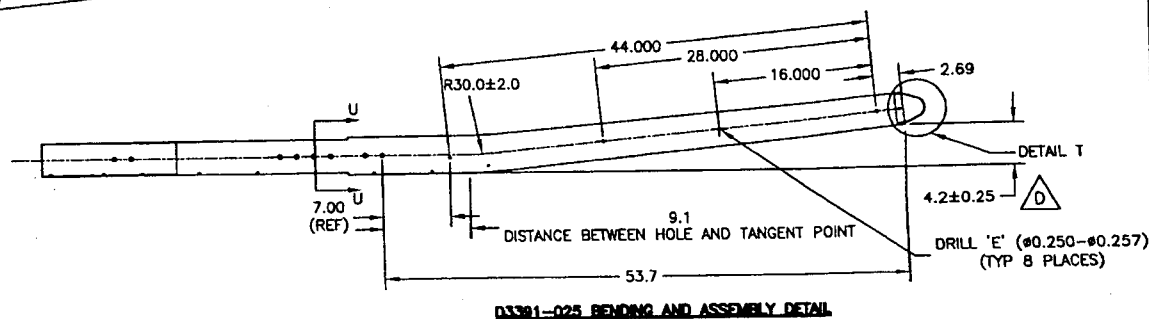
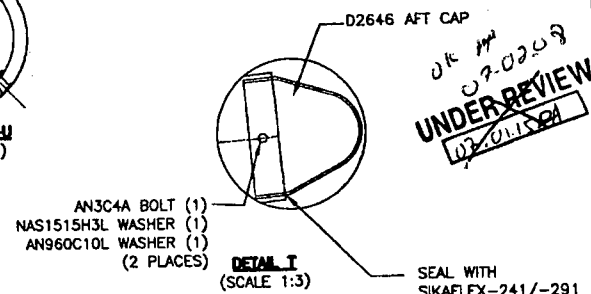
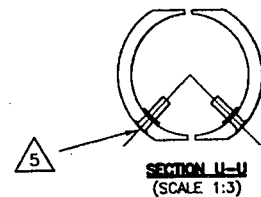


C/SINK AND INSTALL AESS10KBXXX AND/OR NAS1330C3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C/SINK	P/N
CS1	18	14	Ø0.425	AESS10KB366
CS2	2		Ø0.391	AESS10KB366
CS3	2	2	Ø0.391	NAS1330C3KB316
CS4	2	2	Ø0.391	NAS1330C3KB266
CS5	2		Ø0.391	NAS1330C3KB216
CS6	12	8	Ø0.391	NAS1330C3KB166

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
18	14	AESS10KB366	INSERT
4	2	NAS1330C3KB316	INSERT
4	2	NAS1330C3KB266	INSERT
4	2	NAS1330C3KB216	INSERT
12	8	NAS1330C3KB166	INSERT
4		NAS1330C4KB151	INSERT
2	2	AN3C4A	BOLT
2	2	NAS1515H3L	WASHER
2	2	AN960C10L	WASHER



DRILL 'Q' (#0.332-#0.338)
C/SINK (#0.529X100#)
NAS1330C4KB151 INSERT (1)
(4 PLACES)

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DESIGN	PH	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, OH
CHECKED		APPROVED		DRAWING NO. D3391
DATE	06.04.25	TITLE	412 FLOAT SKIDTUBE	REV. E SHEET 5 OF 5 SCALE 1:12

OK 144
07-02-09
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102-0115-01

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09/23/2

DART AEROSPACE LTD		Work Order: 30932
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒
First Article
☐
Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	✓			
3.500	+/-0.010	3.502	✓			
88.93	+/-0.030	88.93	✓			
44.995	+/-0.030	45.00	✓			
3.200	+/-0.010	3.208	✓			
1.526	+0.000/-0.030	1.528	✓			
0.200	+/-0.010	.201	✓			
7.500	+/-0.010	7.501	✓			
27.750	+/-0.010	27.750	✓		m-tape	
31.750	+/-0.010	31.750	✓		"	
35.250	+/-0.010	35.250	✓		"	
0.400	+/-0.010	.401	✓			
0.208	+0.005/-0.001					
3.300	+/-0.010	3.302	✓			
0.200	+/-0.010	.201	✓			
3.520	+/-0.010	3.521	✓			
0.687	+0.010/-0.000	.689	✓			
R0.062	+/-0.010	r.062	✓			
Ø0.484	+0.005/-0.001	.488	✓			

Measured by: J.B. K/JLM	Audited by: J.M.L.	Prototype Approval:	N/A
Date: 07/03/09	Date: 07/03/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	

